

Step 13 (cont.) **Materials:** 2½" dia castiron, 2" dia. x 1¼" CRS., 2½" dia x 1¼" CRS.

Procedure: Turn, bore, and part 3 or 4 castiron blanks as shown. Saw and file gap.

Build O.D. turning fixture part #X08. Compress each blank with hose clamp or ring compressor and bolt on fixture (#X08). Turn O.D. 2.000" - 2.001".

Build I.D. turning fixture part #X09. Slip ring into bore of fixture (#X09) , clamp and bore to 1.860" - 1.858".

You now have perfect circle piston rings. Fit to cylinder at 0.003" 0.004" gap.

Step 14 **VALVES, ROCKER ARM, GUIDES, and etc.:** Sheet #9

Parts: #118 through #125

Materials: ½" x ½" x 6" CRS., ½" dia. x 2¼" brass. ¾" x ½" x 3" CRS., ¼" dia. x 2½" CRS., ⅝" dia. x 5½" CRS., ¾" dia. x 1" CRS., ⅝" dia. x 5½" stainless steel.

Procedure: Part #118: Drill and ream, bolt to spud, turn both sides and finish with file or sander. Part #121 and #122: Turn, drill and tap with 4-jaw, drill, saw, and file openings.

Part #120: CRS. may be substituted for stainless steel.

For the other parts, follow the prints.

Step 15 **CAM IGNITION and GOVERNOR PARTS:** Sheets #5 and #2

Parts: #126 though #141 (sheet #5)
 #142 (sheet #2)

Materials: ⅝" dia. x 7" CRS., ¼" x 1" x 7" CRS., ⅛" x ½" x 4" CRS., ¼" x ½" x 4" CRS., ⅜" dia. x 8½" CRS., 2" x 2" x ¼" x 1¼" angle iron, 1½" dia. x 1" CRS., ¼" dia. x 1½" CRS., ½" dia. x 3¼" CRS., ⅛" x 1" x 3½" HRS., 2" dia. x 1" CRS., 2¼" dia. x ½" CRS.